

Date: Tuesday, 13/01/2009 10:19:30 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 44721
Estimate Number : 13715
P.O. Number :
This Issue : 13/01/2009 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : MACHINED PARTS
Previous Run :
Written By :
Checked & Approved By : mf 09-01-13
Comment : Est Rev:A New Issue 09-01-13 JLM Verified By:DD

Drawing Name : MOUNTING PLATE ASSY
Part Number : D36941
Drawing Number : D3694 REV PREL C
Project Number : N/A
Drawing Revision : PREL C
Material :
Due Date : 20/01/2009 Qty: 3 Um: Each

Additional Product

PRELIMINARY ISSUE
A 09-01-13 per
ECN #09-502P

Job Number:



POSITIVE
RECALL

Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X06000 6061T6 Bar1.00"x4.00"



Comment: Qty.: 0.6300 f(s)/Unit Total : 0.6300 f(s)

6061T6 Bar1.00"x6.00"

BATCH: M110 550

mf 09/01/19

(3)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 7.150" long

mf 09/01/19

(3)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA731Rev: AA & Dwg D3694 Rev: C

2-Tap 10-32 heli-coil holes Manually

2-Deburr per dwg D3694

J.F. 09/01/20

(3)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/20

(3)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL

09/01/21

(20)

Date: Tuesday, 13/01/2009 10:19:30 AM
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Drawing Name: MOUNTING PLATE ASSY

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Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 09-01-21 (3)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*****Mask as per Dwg D3694*****

START TIME: 7:30 AM

OVEN TEMPERATURE: 320°

FINISH TIME: 8:00 AM

HJ 09-01-23

(X2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 09-01-23

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 118

MF 09-02-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



POSITIVE RECALL

EPR: 09-01-13 AUTH: L
REL: DATE: 09-02-12

MF 09-01-24

DART AEROSPACE LTD		Work Order:	44721
Description:		Part Number:	D3694-1
Inspection Dwg:	Rev:	Page 1 of 1	

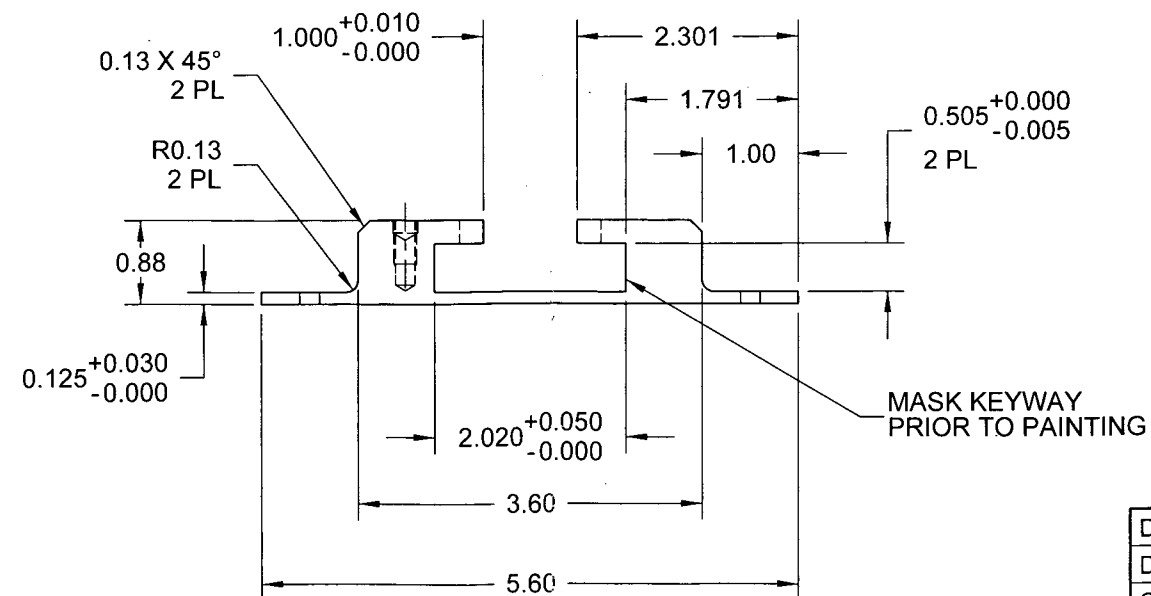
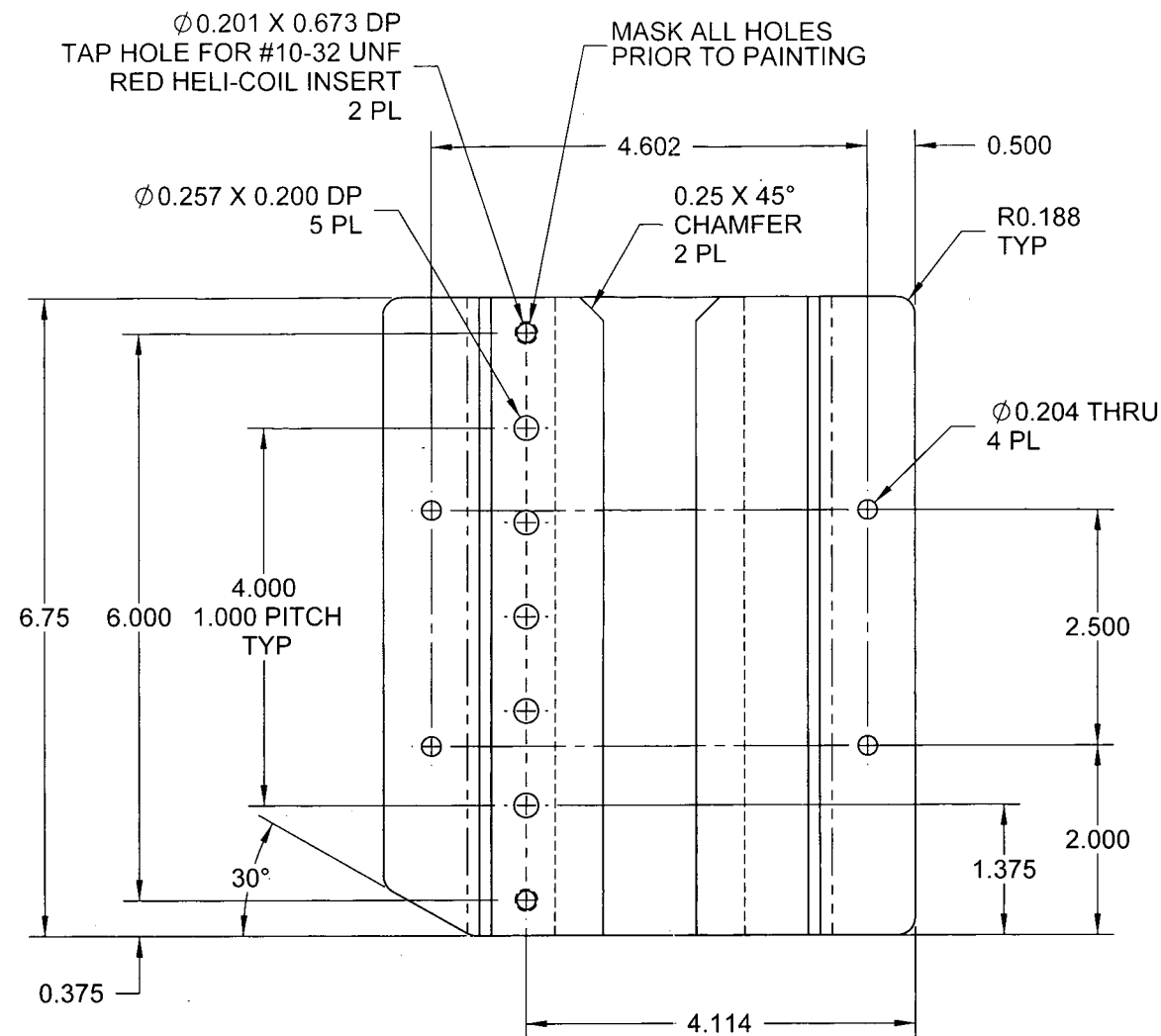
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .201	$\pm .005$ $\pm .001$	Ø .206	✓			2 PL
.673 Dp	$\pm .010$.667	✓			2 PL
Ø .257	$\pm .006$ $\pm .001$	Ø .259	✓			5 PL
.200 Dp	$\pm .010$.204	✓			5 PL
.675	$\pm .030$.6751	✓			
.000	$\pm .010$	5.997	✓			
4.000	$\pm .010$	4.001	✓			
.375	$\pm .010$.383	✓			
* 4.114	$\pm .010$	4.114				
1.375	$\pm .010$	1.384	✓			
2.000	$\pm .010$	2.003	✓			
2.500	$\pm .010$	4.504	✓			
Ø .204	$\pm .005$ $\pm .001$	Ø .205	✓			4 PL
R .188	$\pm .010$	R .188	✓			
4.602	$\pm .010$	4.604	✓			
.500	$\pm .010$.501	✓			
.25 x 45	$\pm .030$.25	✓			2 PL
1.000	$\pm .010$ $\pm .002$	1.001	✓			
.13" x 45°	$\pm .030$.126	✓			2 PL
R .13	$\pm .030$	R .13	✓			
.88	$\pm .030$.880	✓			
.125	$\pm .030$ $\pm .002$.125	✓			
2.020	$\pm .050$ $\pm .000$	2.031	✓			

Measured by:	J.F.	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	09/01/20	Date:	09.01.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3694-1 KEYWAY

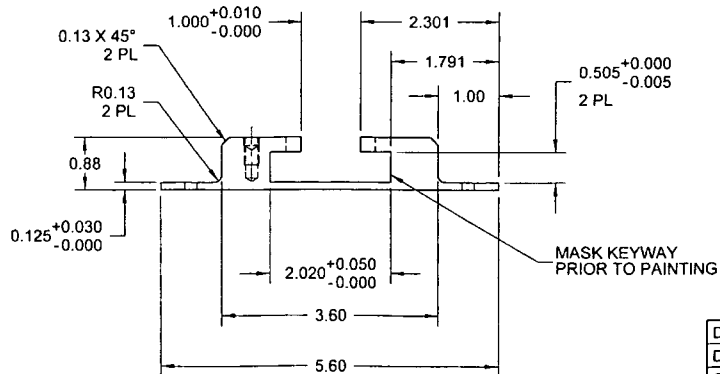
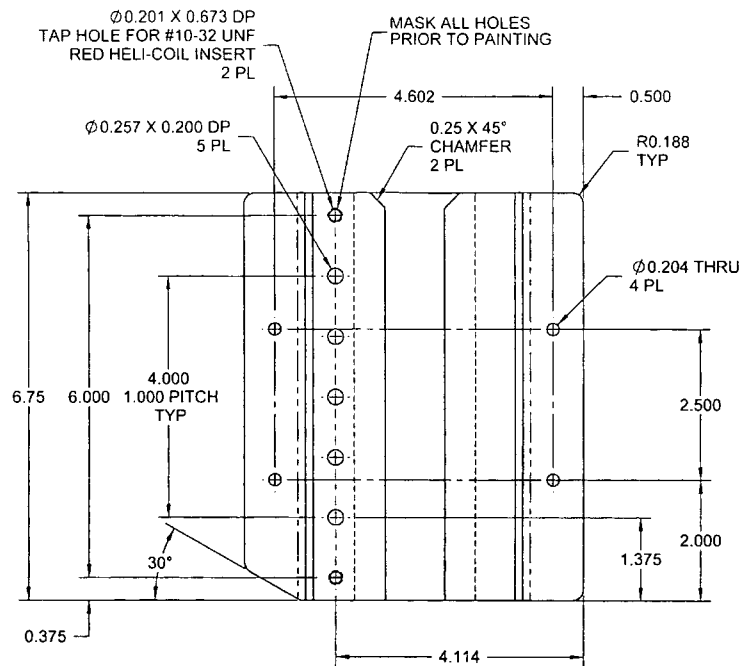
D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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PRELIMINARY ISSUE

44721
Add. 1.13
Rel. 001.13



D3694-1 KEYWAY

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- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.39 lbs

RELEASED
09/06/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3694	REV. C
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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